



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2374
Job Sheet 213081



Part No: D2374

Job Qty: 12 pcs

16 PCS

Part Name: Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/15/20

Job Tracking No:

Due Date: 10/12/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP D 03.04.04 Reformat; Made on Cobra KJ/RF IPP Rev:E Now on Doosan Lathe 08-05-05
JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	12 pcs	10/12/20	10/12/20	1.00	1.98	Doosan - 1	OK 20/10/01
120	QC 8	12 pcs	10/12/20	10/12/20	0.00	0.00	QC 8 - 12	OK 20/10/01
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	
							QC 8 - 61	
							QC 8 - 66	
							QC 8 - 73	



Container No: S304144



Part: D2374

Job No: 213081

Serial No/Batch: S304144

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 10/01/20

3,407

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130 Packaging 3-1 - Stock - B4B 12 pcs <i>16 pcs MKD</i>	10/12/20	0.00 0.00	QC 8 - 82	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	DAS
			Packaging 3 - 7 - B4B	28
			Packaging 3 - 8 - B4B	9-89
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	OCT 01 2020
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	DAS
140 QC 21 - SA 12 pcs	10/12/20	0.00 0.00	QC 21 - SA - 21	2 OCT 02 2020
			QC 21 - SA - 70	9-89
			QC 21 - SA - 9	DAS
			QC 21 - SA - 77	21
			QC 21 - SA - 28	9-89

Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FA156 Rev: AA & Dwg D2374 Rev: A 2- Mill as per Folio FA156 Rev: AA
 Descriptions: AA & Dwg D2374 Rev: A 3-Deburr per dwg D2374
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRRNR1.000	Delrin Round Bar 1" Color: Black	1.5252 ft (.1271 ea)	100-Doosan - 1	5262874

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	MDELRRNR1.000	2	0	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stud	1.000Inches $\pm$ 0.010	1.010 0.990	1	
2	Stud	0.625Inches $\pm$ 0.010	0.635 0.615	.625	
3	Stud	0.500Inches + 0.005 - 0.000	0.505 0.500	.502	Diameter
4	Stud	0.313Inches + 0.005 - 0.000	0.318 0.313	.313	Diameter
5	Stud	0.062Inches $\pm$ 0.010	0.072 0.052	.06	Radius
6	Stud	0.300Inches $\pm$ 0.010	0.310 0.290	.298 .298	
7	Stud	1.313Inches $\pm$ 0.010	1.323 1.303	1.31	
8	Stud	0.125Inches $\pm$ 0.010	0.135 0.115	.128	
9	Stud	0.772Inches $\pm$ 0.010	0.782 0.762	.77	
10	Stud	0.563Inches $\pm$ 0.010	0.573 0.553	.56	Radius

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____ _____ _____					